

# Work Order ID 52457

Friday, September 25, 2009 8:57:10 AM



Page 1

Item ID: D212-664-201

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Aft

Start Date: 9/25/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: PL Date: 09-24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D212-664-241	Rev C								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP D212-664-201		CHG003						
110		0.00							
	Pick Kit								
Packaging	Packaging								
Packaging	Memo	0.00							
120		0.00							
	BENDING MACHINE - CROSSTUBES								
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007								

*5079*

*(P10) 7*

*OK MK 09-10-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-201 PAR #: \_\_\_\_\_ Fault Category: X-tubes NCR: Yes No DQA: / Date: 09-10-20  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 52457		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/13	110	Tube is 1" over bent. operator inserted the work tube on wrong line	MB 09/10/14 09/10/14	-Scrap and Destroy Give to engineering for testing the rig.	MB 09-10-14	S 09/10/14	MB 09/10/14 QSI 042	S 09/10/13
		human error started on 32" tangent instead of 35". Tangent lines were I.D'd with the measurement. operator asked if it was on the correct dimension.	MB 09/10/14				MB 09/10/14	S 09/10/13
		R.C. Lack of Attention.						

NOTE: Date & initial all entries

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



QC15- Crosstube Dimensional Check

0.00

QC

Memo

0.00

Quality Control

140



Crosstubes

0.00

Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 &amp; DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 &amp; DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat as within 24 hours of bending and drilling

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Required Date: 10/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Outsource process - NDT per QSI038 4.1	0.00							
Outsource2	Memo	0.00							
Outsource process - NDT	Liquid Penetrant Inspection as per QSI 038 Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order								
190 	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect for damage & ensure results are as per Dwg D212-664-241								

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Required Date: 10/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

SprayPaint

Memo

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2  
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: \_\_\_\_\_

Fininsh Time: \_\_\_\_\_

PAINT:

Start Time: \_\_\_\_\_

Finish Time: \_\_\_\_\_

220



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Then, Wrap in plastic bag to protect from scratches

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond Batch: \_\_\_\_\_

Expiry Date: \_\_\_\_\_

3-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Required Date: 10/12/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start   
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							
260 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							
270 	Packaging	0.00							
Packaging Packaging	Memo Identify and pack for shipping as per PPP D212-664-201	0.00							



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Reference:

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Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

h 9.10.10

# Picklist Print

Page 1

Friday, September 25, 2009 8:57:09 AM

Work Order ID: 52457



Parent Item: D212-664-201RevC



Parent Item Name: Crosstube Aft

Start Date: 9/25/2009

Required Date: 10/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D212-664- 201TRNRevC		Manufactured	No			110	Each	3.0000	1.0000			



8-52461 MB 09-10-13 ✓

Crosstube Turning Detail

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	3	
46386	1	
50991	1	
51220	1	

D3595-063-530RevA

Manufactured No

230

Each

208.0000

2.0000



RUBBER CUSHION

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	208	
40780	2	
44998	2	
50030	100	
51776	104	

# Picklist Print

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Friday, September 25, 2009 8:57:09 AM

Work Order ID: 52457



Parent Item: D212-664-201RevC



Parent Item Name: Crosstube Aft



Start Date: 9/25/2009

Required Date: 10/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2940-1RevB		Manufactured	No			230	Each	44.0000	2.0000			
												
Support												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>
-----------------

Main Warehouse

ST

44

24367

4

25594

2

45203

18

47748

20

MS21920-28

Purchased

No

230

Each

128.0000

4.0000



Clamp(per MIL-DTL-8783C)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>
-----------------

OFFSHORE

FG

5

105884

5

Main Warehouse

ST

123

106864

5

108466

9

108847

7

109181

14

109965

2

111281

2

111734

34

112624

50

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Shop Packet Print

Page 2

# Picklist Print

Friday, September 25, 2009 8:57:09 AM

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Parent Item: D212-664-201RevC



Parent Item Name: Crosstube Aft

Start Date: 9/25/2009

Required Date: 10/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3428-1RevA		Manufactured	No			250	Each	29.0000	1.0000			
Placard												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST096

29

50790

29

MS21042L6

Purchased

No

250

Each

697.0000

6.0000



Nut

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

697

105077

22

110002

5

111548

70

111578

400

112492

200

AN960JD616

Purchased

No

250

Each

538.0000

18.0000



Washer

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

538

112314

538

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# Picklist Print

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Work Order ID: 52457



Parent Item: D212-664-201RevC



Parent Item Name: Crosstube Aft



Start Date: 9/25/2009

Required Date: 10/12/2009



Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-40A  Bolt		Purchased	No			250	Each	66.0000	4.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	66	
112612	16	
112679	50	

AN6-41A  Bolt		Purchased	No			250	Each	49.0000	2.0000 			
---	--	-----------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	49	
111605	29	
112489	20	

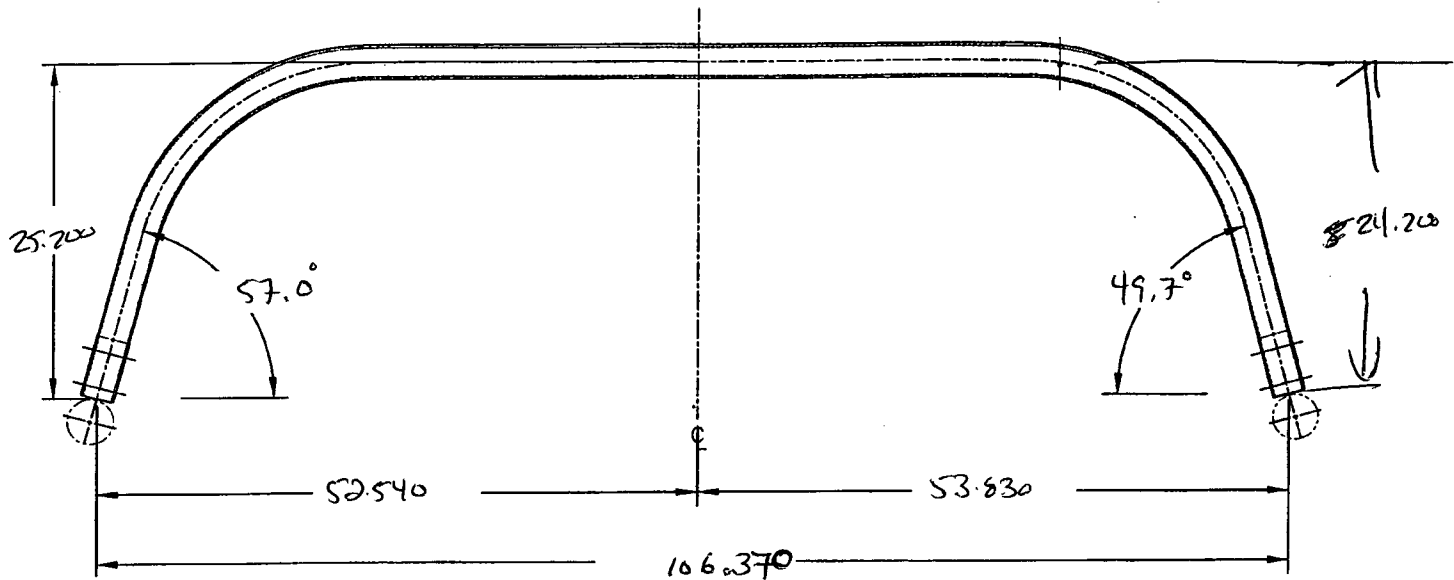
Friday, September 25, 2009 8:57:10 AM

Shop Packet Print

Page 4

DART AEROSPACE LTD		Work Order:	52457
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
tube is scrap / over Bent on one side

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	

**DART****RELEASED**  
07.04.24  
PER ECN 889**DEO ATTACHED**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>PH</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH =  $124.36 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT  
**NOTE:** MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

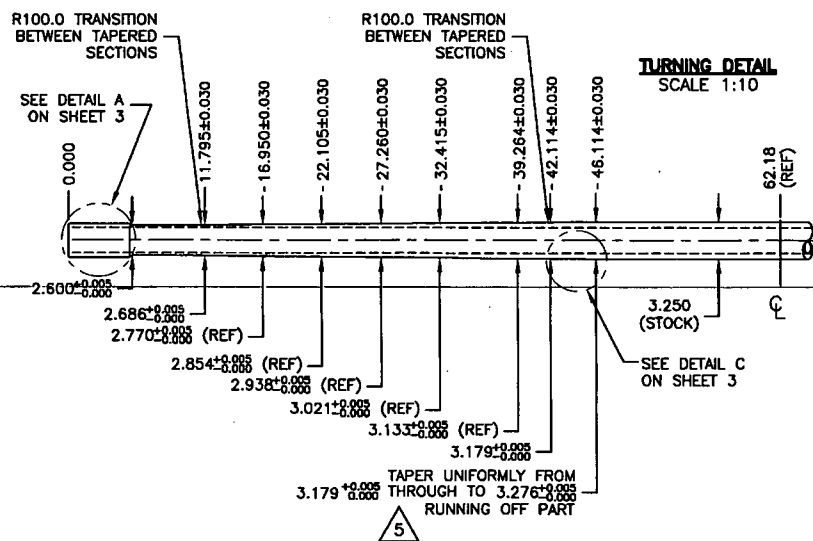
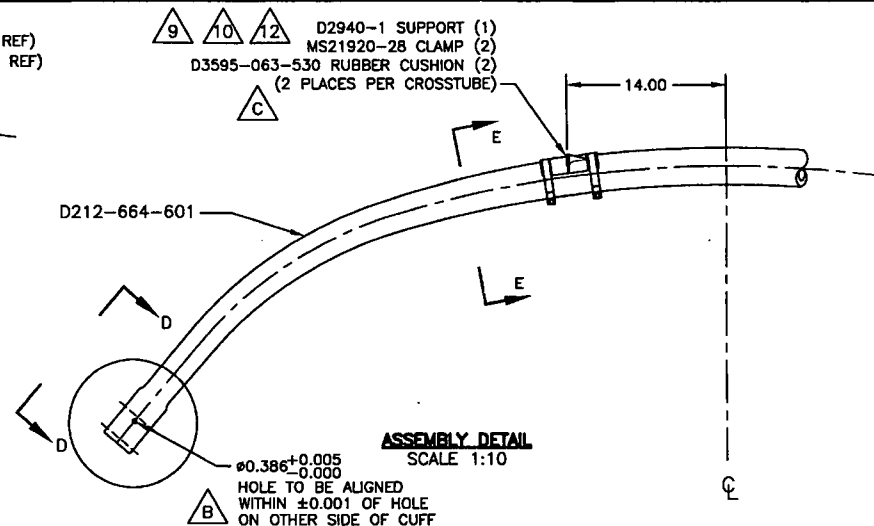
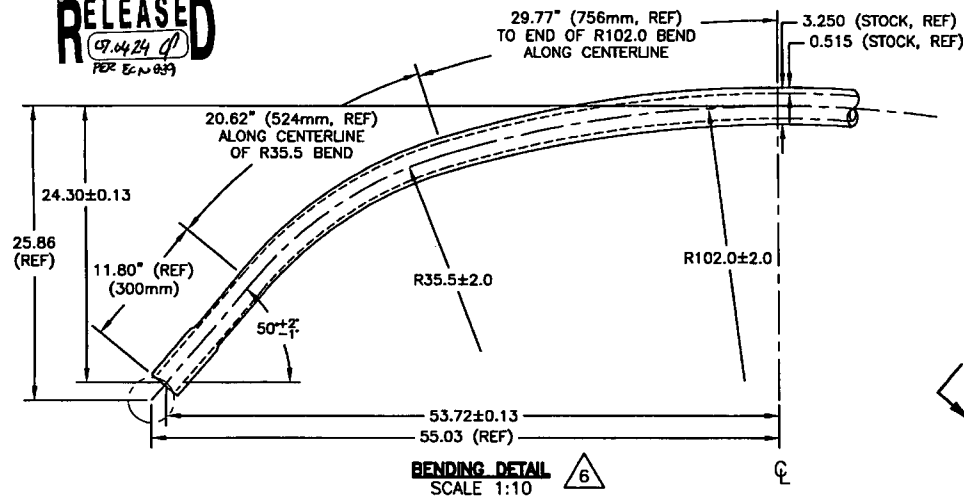
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NO. 52457

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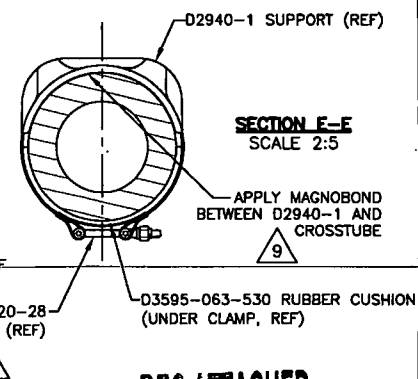
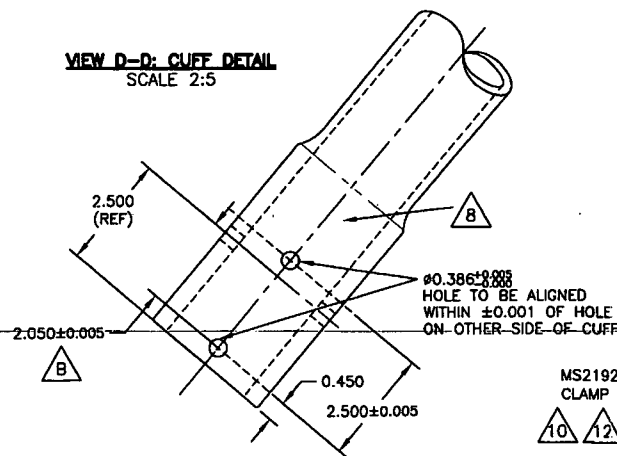
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**RELEASED**  
07.04.24  
PER E-N 039

W/O 52457



**VIEW D-D: CUFF DETAIL**  
SCALE 2:5



**DEO ATTACHED**

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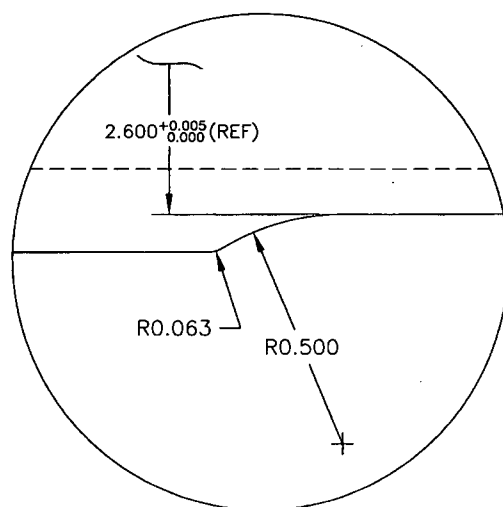
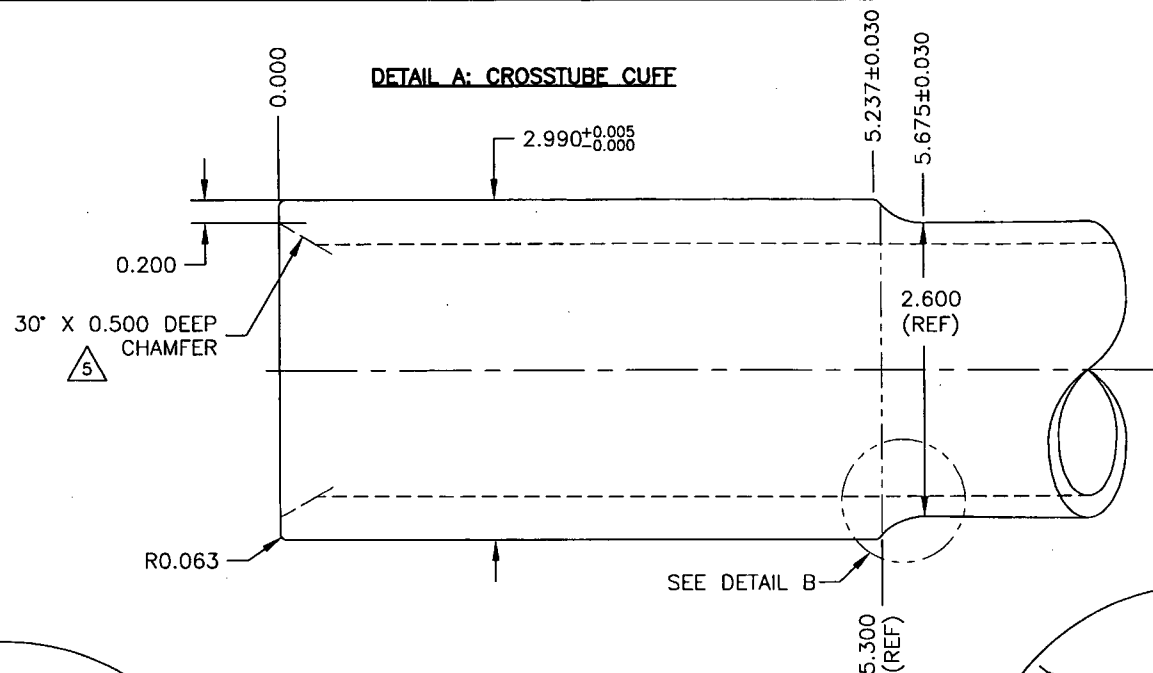
DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED J	APPROVED J	DRAWING NO. D212-664-241	REV. C SHEET 2 OF 3
DATE 07.03.08	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:10	



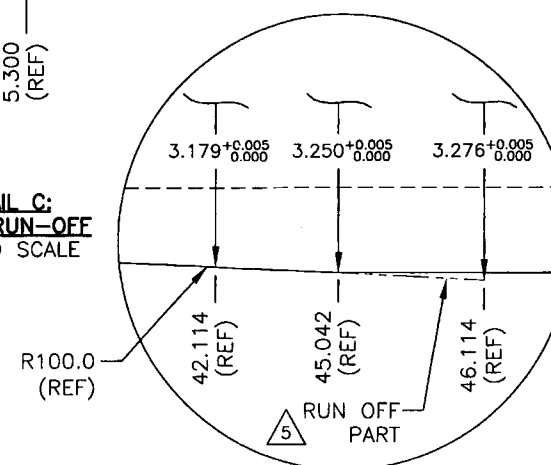
W/6 52457

**RELEASED**  
07.04.24  
PER ECM 889

**DEO ATTACHED**



**DETAIL C: TAPER RUN-OFF**  
NOT TO SCALE



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DESIGN

DRAWN BY

**DART**

**DART AEROSPACE LTD.**  
WARRICKBURY, OXFORD, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. C

DATE

TITLE

SCALE

07.03.08

D212-664-241  
CROSSTUBE ASS'Y (205/212 HI AFT)

1:1

W/O 52457

DRAWING NO. D212-664-241	TITLE CROSSTUBE	REV. C	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D212-664-241-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN UP	CHECKED Rt	MFG. APPR. E	APPROVED MD		DE APPR. H		
DATE 09.05.01	DATE 09.06.15	DATE 09.06.15	DATE 09/06/16		DATE 09/06/16		

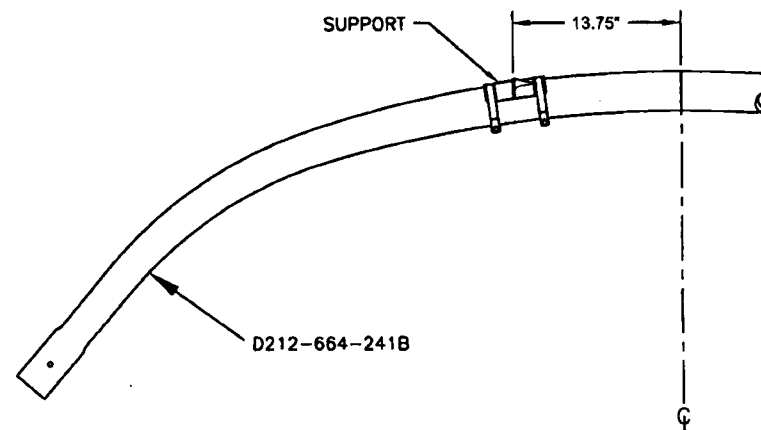
**CHANGE:**

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)

THE D212-664-241B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-241 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-241 CROSSTUBE.

**RELEASED**  
09/06/22



**FIGURE 1 - SUPPORT INSTALLATION**